

Work Order ID 153092

Tuesday, November 08, 2016 10:52:11 AM

153092

Page 1

Item ID: D4917-300 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Placard, Max Load
Start Date: 11/3/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 11/8/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: NOV 09 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4917	A

100

0.00

100

Purchasing

Purchasing

Memo

Issue P/O: 34282
E-mail or Ship electronic file and or dwg to vendor
Manufacture as per Dwg and supplied files
Possible supplier: Studio Letrage
Material release note is required.

0.00

NOV 10 2016

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.02

6x 80/671-J1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective : 2/1A				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition 2/1A					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00				6			DAS 38 9-89 NOV 21 2016
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>5437</u> Memo ***ONE YEAR EXPIRED DATE FROM RECEIVING: <u>NOV 21 2017</u> ***	0.00 0.01				6			DAS 6 9-89 NOV 22 2016
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.10							16/11/22 J DAS 21 9-89 NOV 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Tuesday, November 08, 2016 10:52:11 AM

Page 1

Work Order ID: 153092

153092

Parent Item: D4917-300

D4917-300

Parent Item Name: Placard, Max Load

Start Date: 11/3/2016

Required Date: 11/8/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 13.12.31 NEW ISSUE DD VERF:RQ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4917-300P		Purchased	No				Each	0.0000		6			

D4917-300P

Placard, Max Load

6x SP/6 11-21.

DQA: _____ Date: _____

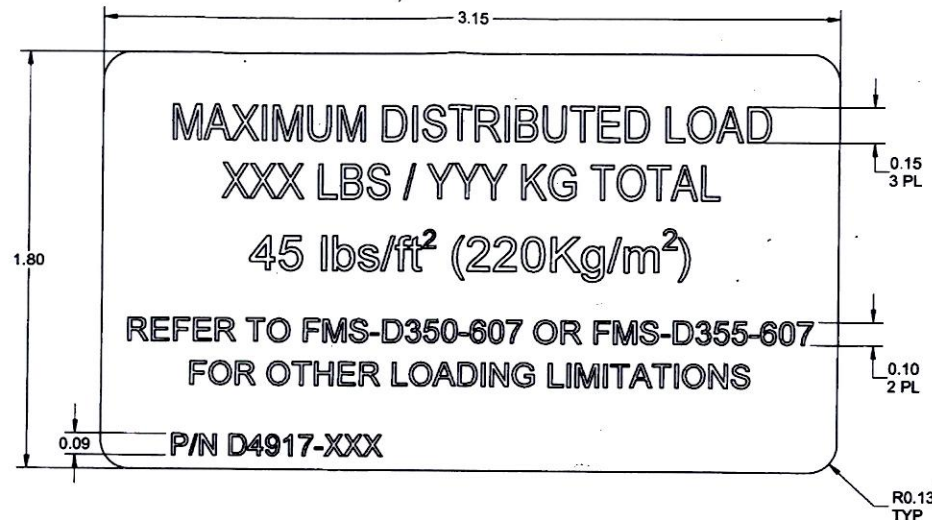


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		OTHER :																							



D4917-XXX PLACARD, MAX LOAD

PART NUMBER	LOAD
D4917-300	300 lbs / (136 kgs)
D4917-310	310 lbs / (141 kgs)
D4917-315	315 lbs / (143 kgs)
D4917-320	320 lbs / (145 kgs)
D4917-332	332 lbs / (151 kgs)
D4917-343	343 lbs / (156 kgs)

NOTES:

- 1) MATERIAL: MAKE FROM 3M 7 MIL MASKING FILM #8522CP ON AVERY IPM #2031 ARIAL FONT, RED LETTERING (0.31 HIGH) ON WHITE ADHESIVE BACK.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART "P/N D4917-XXX" USING ARIAL FONT, RED LETTERING (0.09" HIGH). WHERE XXX = MAX DISTRIBUTED WEIGHT IN LBS PER TABLE
- 7) WEIGHT: LESS THAN 0.01 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 153092 MJS

16-11-09

2017-01-13
A.P. ECU 13-672

A	NEW ISSUE	AJS	13.06.06
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4917	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	PLACARD, MAX LOAD	NTS
DATE	13.06.06	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO34282

Purchase Order Date 11/10/2016

PO Print Date 11/10/2016

Page Number 1 of 2

Order From :

VC-STU001

STUDIO DE LETTRAGE 2001
210 MAIN WEST
HAWKESBURY, ON K6A 2H6
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
NOV 11 2016

Contact Name

Vendor Phone 613 632 5449

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D4086-200P AS PER DWG D4086 REV. B B153070	Placard, Max Load	11/17/2016 Yes 11/17/2016		6.00 Each	\$13.33	\$80.00
Line Total:							\$80.00
2	D4917-300P AS PER DWG D4917 REV. A B153092	Placard, Max Load	11/17/2016 Yes 11/17/2016		6.00 Each	\$13.33	\$80.00
Line Total:							\$80.00
3	D5418-1P AS PER DWG D5418 REV. A B153110	Placard	11/17/2016 Yes 11/17/2016	FN	6.00 Each	\$13.33	\$80.00
Line Total:							\$80.00

Note:

11/10/2016

NOV 21 2016

DAS
26
9-89

studio sl2

210 Main Street West
Hawkesbury, ON K6A 2H6
Phone # 613-632-2001

Invoice

Date	Invoice #
11/14/2016	43396

Invoice To

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury
Ontario
K6A 1K7

Ship To

P.O. No.	Terms	Rep	Ship	Via	F.O.B.	Project
34282			11/14/2016			

Quantity	Item	Description	Price Each	Amount
6	4005	D4086-200P.	13.33	79.98
6	4005	D4917-300P.	13.33	79.98
6	4005	D5418-1P.	13.33	79.98
		Attn: Chantal Ref: 19169		
		NOV 21 2016		
		DAS 38 9-89		
		DAS 38 9-89		

Subtotal \$239.94

Sales Tax \$31.19

Total \$271.13

Thank you for your business.

******CERTIFICATE of CONFORMITY******

Customer:

Studio de Lettrage 2001

Purchase Order N°:

PO 34282

Packing Slip N°:

WO 19169

Part N°:

Serial N°:

Description:

D4086-200P, D4917-300P,
D5418-1P.

Quantity:

6,6,6.

Certification:

We hereby certify that:

1. The above listed items were manufactured, repaired and/or inspected in accordance with applicable drawings and/or specifications;
2. All work was accomplished in accordance with the Dart Aerospace Purchase Order;
3. Results of all inspections, chemical or physical tests, as well as other evidence, which shows the acceptability of raw materials, parts and/or assembly components are on file and available for inspection at any time.

Authority:

Avery.

APPROVAL:

Valerie Young

Signature:

Valerie Young

Title:

office administrator

DATE:

Nov 18.16

PRODUCT DATA SHEET



Avery® IPM I™ 7112

issued: 15/04/2002

Introduction

Avery IPM I 7112 is a white monomeric calendered removable self-adhesive vinyl for use on the Idanit 162Ad inkjet printer, providing good machine runnability. Because of its cost efficiency and good removability, Avery IPM I 7112 is recommended for a wide range of short term applications on flat substrates requiring easy and clean removal.

Description

Film : 100 micron gloss white monomeric calendered vinyl
Adhesive : **removable**, acrylic based
Backingpaper : kraft paper, 140 g/m²

Conversion

Avery IPM I 7112 is specially developed for use on the Idanit 162Ad and Idanit Novo inkjet printer and has been officially approved by Idanit using BL and Magic inks.

Uses

- Interior & exterior signs.
- Window decoration.
- Temporary promotional and point of sale advertising and all.
- applications to flat or regular surfaces that require removability.

Features

- Good printability and handling on Idanit 162Ad.
- Easy conversion.
- Most economical solution for short term outdoor graphics.
- Easy and clean removal (up to 1 year).



www.averygraphics.com

Graphics Division
Rijndijk 86, P.O. Box 118
2394 ZG Hazerswoude - The Netherlands
Tel +31 71 3421500 - Fax +31 71 3421538

PRODUCT CHARACTERISTICS

Avery® IPM I™ 7112

Physical properties

Features	Test method ¹	Results
Caliper, facefilm	ISO 534	100 micron
Opacity	ISO 2471	92%
Dimensional stability	DIN 30646	0.3 mm max.
Adhesion, initial	FINAT FTM-1, stainless steel	225 N/m
Adhesion, ultimate	FINAT FTM-1, stainless steel	400 N/m
Flammability		Self extinguishing
Shelf life	Stored at 22° C/50-55 % RH	2 years
Removability		up to 1 year*
*Not when applied to: Nitrocellulose paints, ABS, Polystyrene, screenprinting inks (fresh), certain types of PVC		
Durability, unprinted	Vertical exposure	2 years

Temperature range

Features	Results
Minimum application temperature:	≥ 0° C
Temperature range:	- 40 to +100 °C

Important

Information on physical and chemical characteristics is based upon tests we believe to be reliable. The values listed herein are typical values and are not for use in specifications. They are intended only as a source of information and are given without guarantee and do not constitute a warranty. Purchasers should independently determine, prior to use, the suitability of this material to their specific use. All technical data are subject to change.

Warranty

Avery® branded materials are manufactured under careful quality control and are warranted to be free from defect in material and workmanship. Any material shown to our satisfaction to be defective at the time of sale will be replaced without charge. Our aggregate liability to the purchaser shall in no circumstances exceed the cost of the defective materials supplied. No salesman, representative or agent is authorised to give any guarantee, warranty, or make any representation contrary to the foregoing. All Avery® branded materials are sold subject to the above conditions, being part of our standard conditions of sale, a copy of which is available on request.

1) Test methods

More information about our test methods can be found on our website.

2) Durability

The durability is based on middle European exposure conditions. Actual performance life will depend on substrate preparation, exposure conditions and maintenance of the marking. For instance, in the case of signs facing south; in areas of long high temperature exposure such as southern European countries; in industrially polluted areas or high altitudes, exterior performance will be decreased.



www.averygraphics.com

Graphics Division

Rijndijk 86, P.O. Box 118
2394 ZG Hazerswoude - The Netherlands
Tel +31 71 3421500 - Fax +31 71 3421538